

Shop 18/06

Dart Aerospace Ltd.

Date: Tuesday, 1/8/2008 1:18:10 PM  
 User: Kim Johnston

## Process Sheet

5

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206L BASKET BASE
Job Number	36654A		
Estimate Number	11273		
P.O. Number		Part Number	D2252041
This Issue	1/8/2008	S.O. No.	D2252 REV E
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	E
Previous Run	35657A	Material	
Written By		Due Date	1/31/2008
Checked & Approved By	10/08.01.08	Qty:	1 Um: Each
Comment	Est Rev. I Revised as per Rev E 05-12-06	JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Pick:	
	Qty Part# Description Batch		
	5 D3166-1 Hoop	B39673(5) <del>(S)</del> SAD 08/06/11 A	
2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)	
		3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: H108663	SAD 08/06/11
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.	
		Cut 5 D2235-1 From D3166-1	
		2- Cut Ribs as per Dwg D2252	
		3-Drill hole in D2252-1as per Dwg D2252	
		4-Deburr & Remove all Markings from Material	SAD 08/06/11
4.0	D22531	Lug	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number Description Batch		
	2 D2253-1 Gusset	B35685	 PCL 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 36654A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Bushing	<u>B37541</u>

*LPL 08-06-12*

6.0 D2581 Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2581	Mounting Chanel	<u>B39046</u>

*LPL 08-06-12*

7.0 D2254 Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2254	Lug	<u>B23421</u>

*LPL 08-06-12*

8.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	HINGE	<u>B36846</u>

*LPL 08-06-12*

9.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
32 sf	M304EX0.75-16F	Expanded Metal	<u>M107966</u>

*SAP 08/06/12 C*

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig/Deburr as required

A/R SS ROD Batch: M106762

*LPL 08-06-16*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: 206L BASKET BASE

Job Number: 36654A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11 08/06/16

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/16 (P)

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

RJ/6L 08/06/17

①

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 08/06/17 (P)

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

E 08/06/17 (P)

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/19 (P)

Job Completion



U Shedd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/17	13.0	<p><u>1<sup>st</sup> Coat</u>  start time: 8:00  Temperature: 400°  Finish time: 8:30</p> <p><u>2<sup>nd</sup> Coat</u>  <u>8:45</u>  400°  9:15</p>			FD QV	08/06/17		L	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



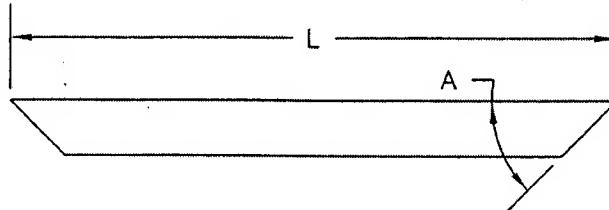
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CHECKED <del>11</del>	APPROVED <del>11</del>	DRAWING NO. D2252		REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)		SCALE NTS
C	95.12.11	RE-DRAWN		
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3		
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19		

**RELEASED**  
05.11.26 - ~~11~~

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

**NOTES:**

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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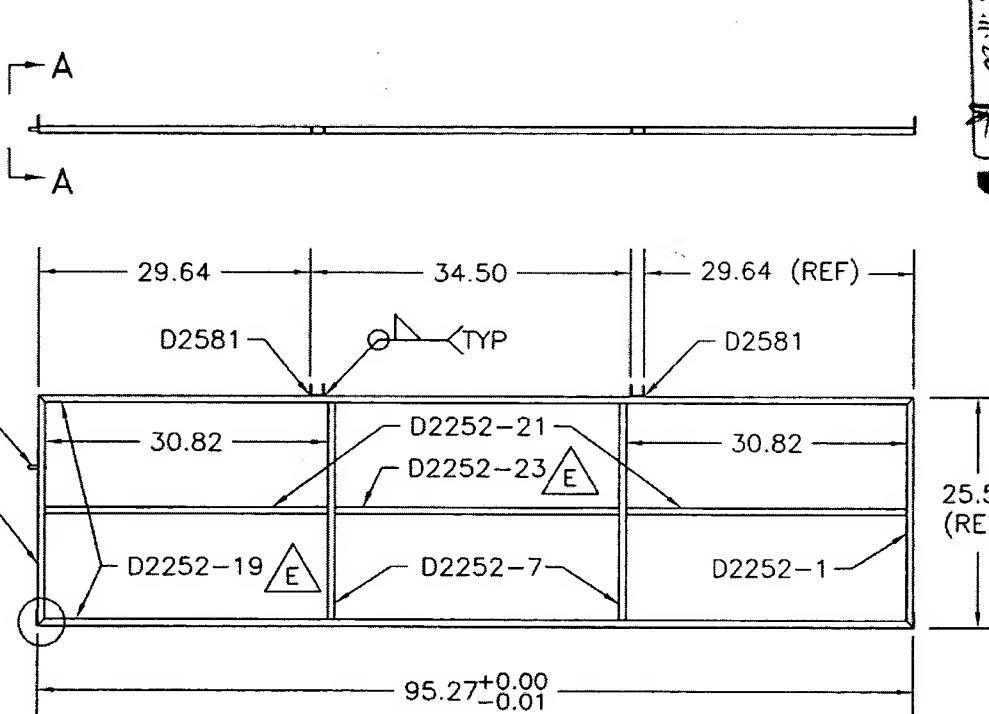
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		D2252
DATE		SHEET 2 OF 5
05.11.10		REV. E
		TITLE
		BASKET ASSEMBLY (206L)
		SCALE
		NTS



D2252-043 LID FRAME

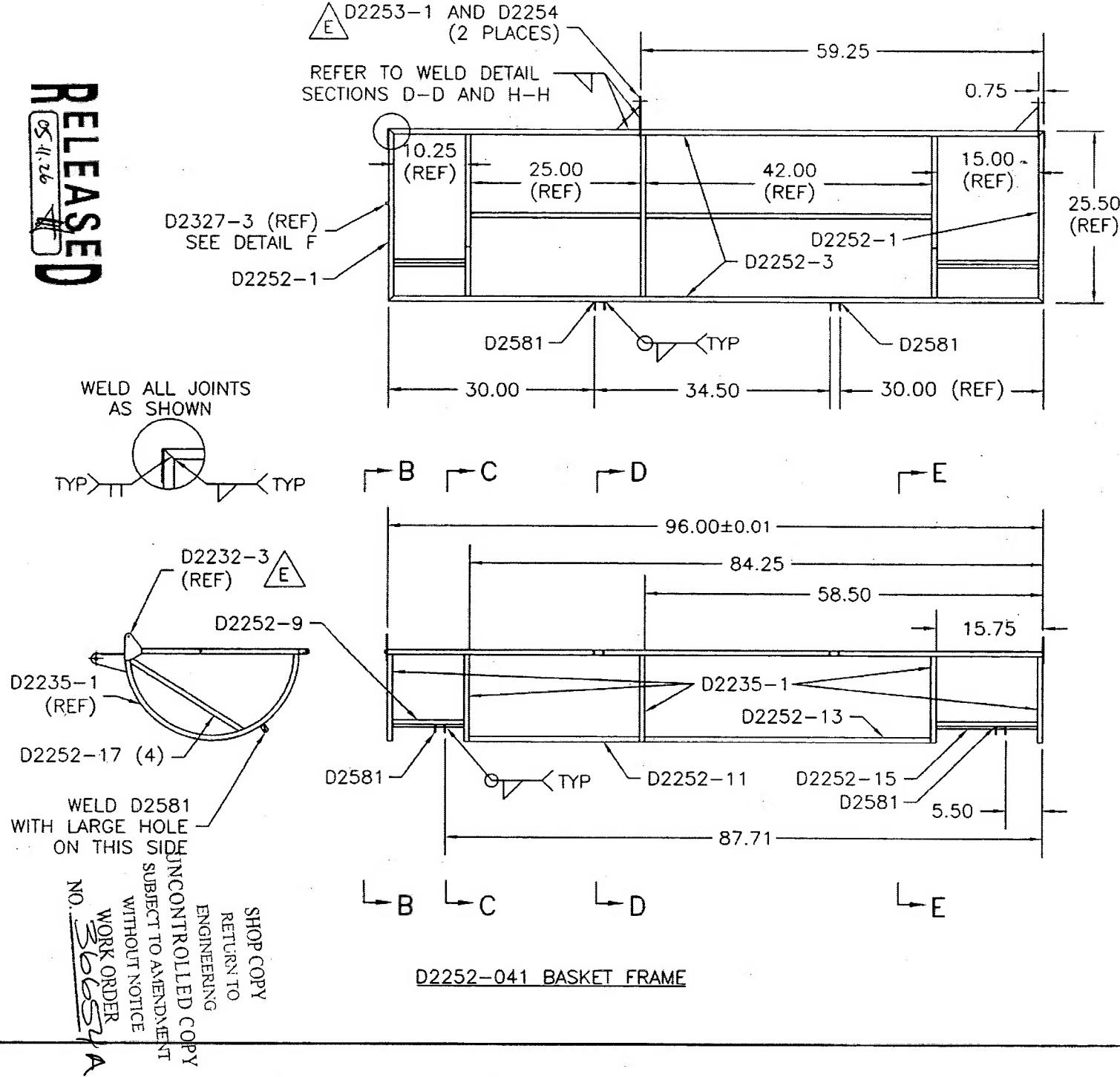
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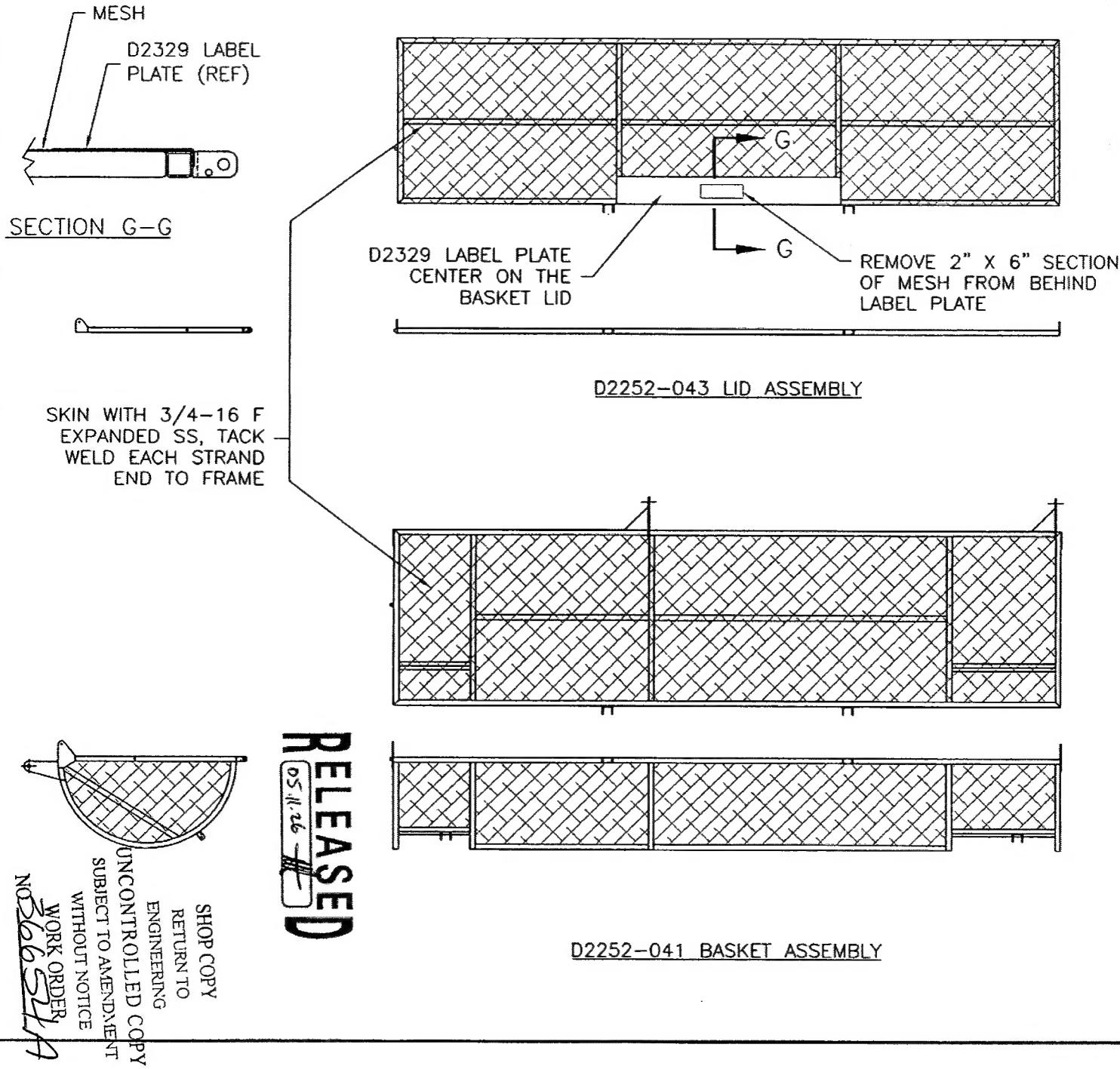
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05.11.10		REV. E
	TITLE	SCALE NTS
	BASKET ASSEMBLY (206L)	

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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SCALE N/A		

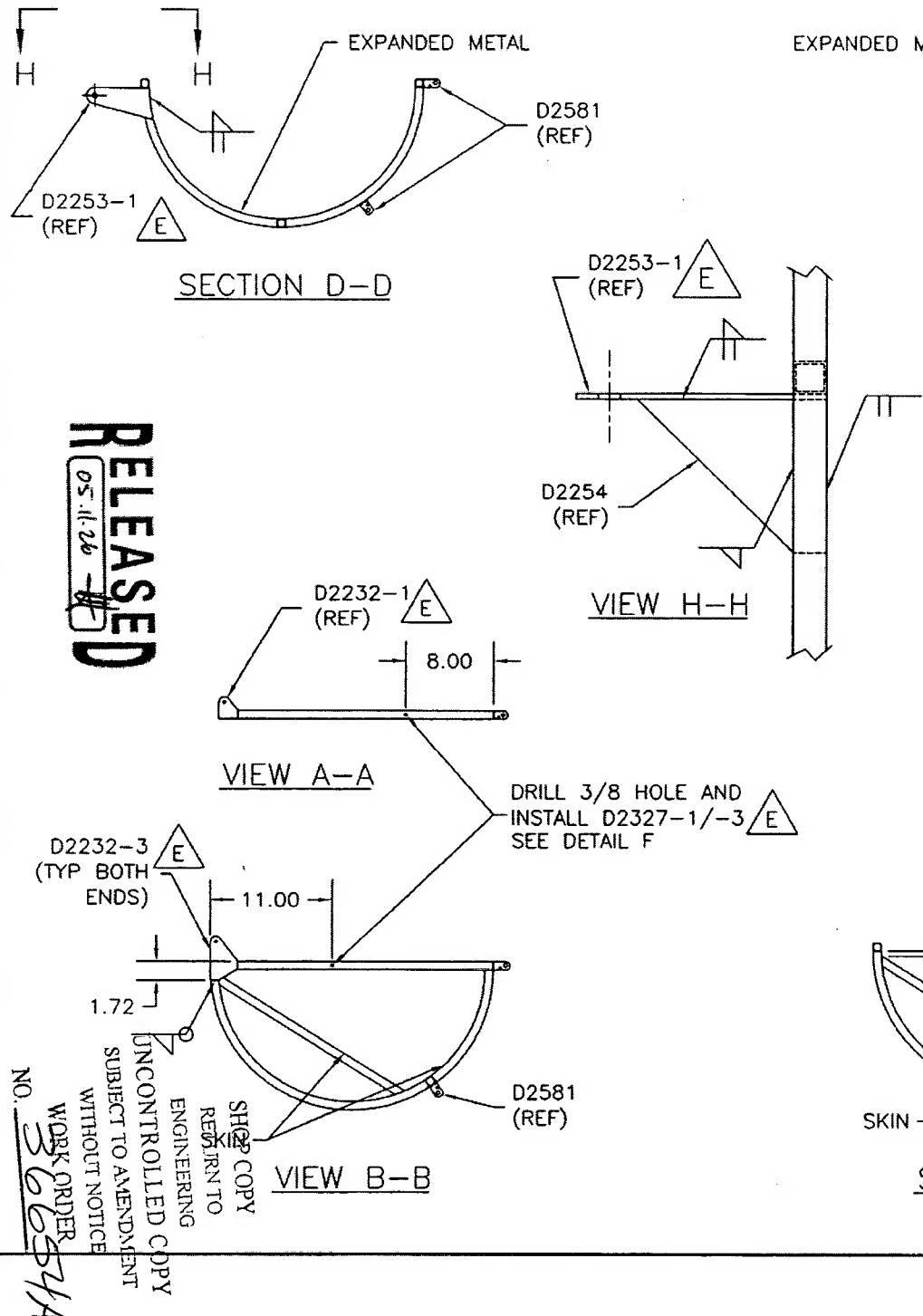


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